

Work Order ID 76729 -1

November-21-11 8:21:39 AM

76729

U/R

Page 1

Item ID: D2940-1

Revision ID: U/R

Item Name: Support

Start Date: 21/11/2011 Start Qty: 20.00

Required Date: 03/01/2012 Req'd Qty: 20.00

Reference:

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

Customer:

Approvals: Process Plan: M.C.J

Date: 11/11/21 Tooling:

Date:

Run Start *NR1*

QC:

Date: SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2940

C

100

0.00

100

HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

1-Machine as per Folio FA079
2-Debur

110

0.00

110

QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

120

0.00

120

QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 76729

November-21-11 8:21:39 AM

76729

Page 3

Item ID: D2940-1

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Item Name: Support

Start Date: 21/11/2011 Start Qty: 20.00

Required Date: 03/01/2012 Req'd Qty: 20.00

Reference:

Accept

N900040100

Setup Start

NS1

Stop

NS2

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

Stop

NR2

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

180

180

QC

Quality Control

Operation
Description

QC21- Final Inspection - Work Order Release

Memo

Set Up/
Run Hours

0.00

0.00

Tool ID

Tool #


Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

11/12/8 

ME

11-12-08

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

November-21-11 8:21:43 AM

Page 1

Work Order ID: 76729

76729

Parent Item: D2940-1

D2940-1

Parent Item Name: Support

Start Date: 21/11/2011

Required Date: 03/01/2012

Start Qty: 20.00

Required Qty: 20.00

Comments:

IPP C 02.11.26Reformat: Added P/OKJ

IPP Rev:D Added priming as per Rev B 07-04-30 JLM

IPP E 08.03.19 Re-format Ec verified by DD

IPP Rev:F 08-10-22 add qc14 DD verified by:EC

IPP Rev:G

11.08.04 as per dwg rev.C DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
DSK081		Manufactured	No			110	Each	4.0000	0.5	10.52632			

DSK081

D2940-1 TURNING DETAIL

**

Location

Loc Qty

Loc Code

MAT020

4

69717

4

76-148

10

10

ISC

11/12/11

W/O:		WORK ORDER CHANGES					
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DART AEROSPACE LTD		Work Order:	76729
Description: Ø3.250 Support		Part Number:	D2940-1
Inspection Dwg: D2940	Rev: B	Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
HAAS Section								
AA	0.240	0.260		.250	.250	.250	.250	.250
AB	0.490	0.510		.500	.500	.500	.500	.500
AC	0.140	0.160		.155	.155	.155	.155	.155
AD	3.510	3.530		3.524	3.524	3.524	3.524	3.524
AE	1.633	1.673		1.660	1.660	1.660	1.660	1.663
AF	1.493	1.513		1.505	1.505	1.505	1.505	1.505
AG	0.040	0.060		.050	.050	.050	.050	.050
AH	0.188	0.193		.188	.188	.188	.188	.188
AI	0.140	0.160		.150	.150	.150	.148	.148
AJ	2.518	2.538		2.528	2.528	2.528	2.528	2.528
AK	0.040	0.060		.050	.050	.050	.050	.050
AL	0.010	0.020		.010	.010	.010	.010	.010
AM	0.140	0.160		.150	.150	.150	.150	.150
AN	0.350	0.450		.400	.400	.400	.400	.400
AO	0.240	0.260		.250	.250	.250	.250	.250
AP	0.150	0.170		.162	.162	.160	.160	.160
AQ	0.053	0.073		.066	.066	.066	.066	.066
AR	101.64	105.64		✓	✓	✓	✓	✓
AS	0.260	0.267		.260	.260	.260	.260	.260
AT	0.053	0.073		.063	.063	.063	.063	.063
AU	4.118	4.138		4.135	4.135	4.138	4.138	4.138
AV								
AW								
Accept/Reject								

Measured by: <u>BC/J</u>	Date: <u>11/11/28</u>
Audited by: <u>BA</u>	Date: <u>11/12/03</u>
Prototype Approval:	Date:

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	
B	07.05.08	Dwg Rev. updated	KJ/JLM	
C	07.07.18	Dimension AS revised	KJ/JLM	
D	08.04.22	Reformat	KJ/JLM	

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	76729
Description: Ø3.250 Support		Part Number:	D2940-1
Inspection Dwg: D2940	Rev: B	Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	16 1	17 2	18 3	19 4	20 5
HAAS Section								
AA	0.240	0.260		.250	.250	.250	.250	.250
AB	0.490	0.510		.500	.500	.500	.500	.500
AC	0.140	0.160		.150	.150	.150	.150	.150
AD	3.510	3.530		3.522	3.522	3.522	3.522	3.522
AE	1.633	1.673		1.660	1.660	1.660	1.660	1.660
AF	1.493	1.513		1.505	1.505	1.505	1.505	1.505
AG	0.040	0.060		.050	.050	.050	.050	.050
AH	0.188	0.193		.188	.188	.188	.188	.188
AI	0.140	0.160		.150	.150	.150	.150	.150
AJ	2.518	2.538		2.528	2.528	2.528	2.528	2.528
AK	0.040	0.060		.050	.050	.050	.050	.050
AL	0.010	0.020		.010	.010	.010	.010	.010
AM	0.140	0.160		.150	.150	.150	.150	.150
AN	0.350	0.450		.400	.400	.400	.400	.400
AO	0.240	0.260		.250	.250	.250	.250	.250
AP	0.150	0.170		.160	.160	.160	.160	.160
AQ	0.053	0.073		.060	.060	.060	.060	.060
AR	101.64	105.64		✓	✓	✓	✓	✓
AS	0.260	0.267		.260	.260	.260	.260	.260
AT	0.053	0.073		.060	.060	.060	.060	.060
AU	4.118	4.138		4.135	4.135	4.135	4.135	4.135
AV								
AW								
Accept/Reject								

Measured by: <u>SC-1 SA</u>	Date: <u>11/12/01</u>
Audited by: <u>W-1263 H</u>	Date: <u>11/12/03</u>
Prototype Approval:	Date:

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	
B	07.05.08	Dwg Rev. updated	KJ/JLM	
C	07.07.18	Dimension AS revised	KJ/JLM	
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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 76729
Description: Ø3.250 Support		Part Number: D2940-1
Inspection Dwg: D2940	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1 1	12 2	13 3	14 4	15 5
HAAS Section								
AA	0.240	0.260		.250	.250	.250	.250	.250
AB	0.490	0.510		.500	.500	.500	.500	.500
AC	0.140	0.160		.150	.150	.150	.150	.150
AD	3.510	3.530		3.522	3.522	3.525	3.522	3.522
AE	1.633	1.673		1.660	1.660	1.660	1.660	1.660
AF	1.493	1.513		1.505	1.505	1.505	1.505	1.505
AG	0.040	0.060		.050	.050	.050	.050	.050
AH	0.188	0.193		.188	.188	.188	.188	.188
AI	0.140	0.160		.150	.150	.150	.150	.150
AJ	2.518	2.538		2.528	2.528	2.528	2.528	2.528
AK	0.040	0.060		.050	.050	.050	.050	.050
AL	0.010	0.020		.010	.010	.010	.010	.010
AM	0.140	0.160		.148	.150	.150	.150	.150
AN	0.350	0.450		.400	.400	.400	.400	.400
AO	0.240	0.260		.250	.250	.250	.250	.250
AP	0.150	0.170		.160	.160	.160	.160	.160
AQ	0.053	0.073		.06	.06	.06	.06	.06
AR	101.64	105.64		✓	✓	✓	✓	✓
AS	0.260	0.267		.260	.260	.260	.260	.260
AT	0.053	0.073		.063	.063	.063	.063	.063
AU	4.118	4.138		4.135	4.135	4.135	4.135	4.135
AV								
AW								
Accept/Reject								

Measured by:	Date: 11/1/13
Audited by: BA	Date: 11/12/13
Prototype Approval:	Date:

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	
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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 76729
Description: Ø3.250 Support		Part Number: D2940-1
Inspection Dwg: D2940	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				6 1	7 2	8 3	9 4	10 5
HAAS Section								
AA	0.240	0.260		0.250	0.250	0.250	0.250	0.250
AB	0.490	0.510		0.500	0.500	0.500	0.500	0.500
AC	0.140	0.160		0.155	0.155	0.155	0.155	0.155
AD	3.510	3.530		3.524	3.524	3.524	3.524	3.524
AE	1.633	1.673		1.663	1.663	1.663	1.663	1.663
AF	1.493	1.513		1.505	1.505	1.505	1.505	1.505
AG	0.040	0.060		0.050	0.050	0.050	0.050	0.050
AH	0.188	0.193		0.188	0.188	0.188	0.188	0.188
AI	0.140	0.160		0.148	0.148	0.148	0.148	0.148
AJ	2.518	2.538		2.528	2.528	2.528	2.528	2.528
AK	0.040	0.060		0.050	0.050	0.050	0.050	0.050
AL	0.010	0.020		0.010	0.010	0.010	0.010	0.010
AM	0.140	0.160		0.150	0.150	0.150	0.150	0.150
AN	0.350	0.450		0.400	0.400	0.400	0.400	0.400
AO	0.240	0.260		0.250	0.250	0.250	0.250	0.250
AP	0.150	0.170		0.160	0.160	0.160	0.160	0.160
AQ	0.053	0.073		0.06	0.06	0.06	0.06	0.06
AR	101.64	105.64		✓	✓	✓	✓	✓
AS	0.260	0.267		0.260	0.260	0.260	0.260	0.260
AT	0.053	0.073		0.063	0.063	0.063	0.063	0.063
AU	4.118	4.138		4.138	4.138	4.138	4.138	4.138
AV								
AW								
Accept/Reject								

Measured by: EC	Date: 11/11/29
Audited by: B.P.	Date: 11/12/03
Prototype Approval:	Date:

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A	02.12.12	New Issue	KJ/RF	
B	07.05.08	Dwg Rev. updated	KJ/JLM	
C	07.07.18	Dimension AS revised	KJ/JLM	
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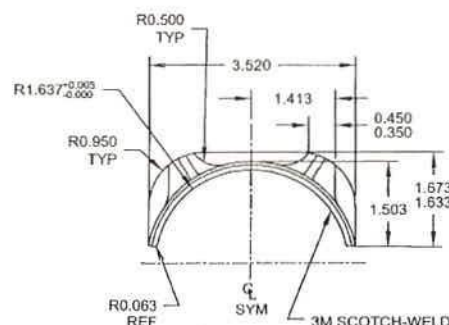
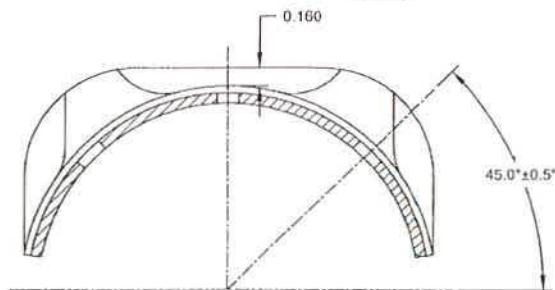
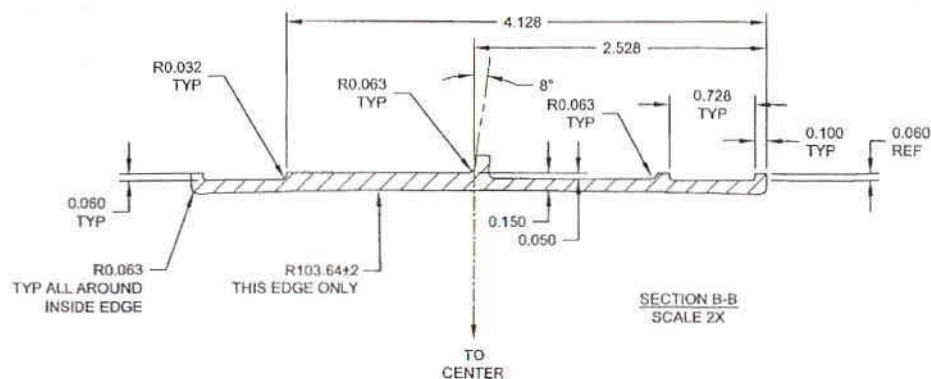
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

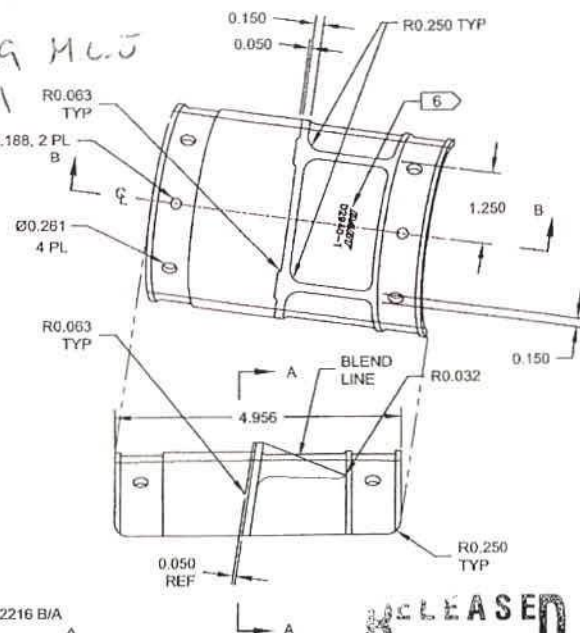
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries



76729 M.C.S.
11/1/21



NOTES:

- 1) MATERIAL: 17-4 PH STAINLESS STEEL, H900 OR H925 CONDITION
MIN UTS = 170 KSI (38 HRC)
(REF DART SPEC. D6104)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 (REF X.XXX = ±0.010) UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: DART LOGO (PER DART SUPPLIED GRAPHIC) AND PART NUMBER IN THIS AREA WITH 0.125 HIGH LETTERING
0.010-0.020 DEEP, PER DART QSI 044 6.3.
- 7) WEIGHT: 0.92 lb
- 8) FOR THE ENTIRE INNER CONCAVE SURFACE:
ABRADE SURFACE WITH 400-GRIT SANDPAPER. REMOVE RESIDUE WITH MEK (OR EQUIVALENT). APPLY 0.03" TO 0.05" THICK LAYER OF 3M SCOTCH-WELD 2216 B/A ADHESIVE TO MATING SURFACE OF SUPPORT. ALLOW TO CURE FOR 24 HOURS.

D2940-1 SUPPORT

C	RMV FINISH, ADD 3M 2216, ADD H925 MATL OPTION	CP	11.07.15
B	UPDATE PER NCR 642, PRIME INSIDE	PH	07.03.13
A	NEW ISSUE	CP	01.01.10
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	11.07.15		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO.
D2940

TITLE
Ø3.250 SUPPORT

REV. C
SHEET 1 OF 1

SCALE
NTS

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RELEASED
2011-07-28

W/O:		WORK ORDER CHANGES					
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